

Work Order ID 133338

Thursday, June 04, 2015 10:00:11 AM

133338

Page 1

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 6/08/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/12/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 15-6-4 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3915	E								

100

Weld per dwg A/R Aluminum rod Batch: B130855 0.00
 Large Fab

100

Large Fab

Large Fab

Memo

0.00

1- assemble ribs, weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

1x CC 15-6-8

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

1x DAS 43 9-89 JUN 08 2015

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Start Date: 6/08/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/12/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing	***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***								
140	Weld per dwg A/R Aluminum rod Batch: 3130855	0.00							
140									
Large Fab	Memo	0.00							
Large Fab	1- weld (4) corners								

DAS
43
9-89

JUN 08 2015

1x CC 15-6-8

1x CC 15-6-8

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Item ID: D3915-041

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Revision ID:

Stop ***NS2***

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Start Date: 6/08/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/12/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							
Quality Control									
155	QC6- Inspect dimensions to drawing	0.00							
155									
QC	Memo	0.00							
Quality Control	***inspect fit of lid with base***								
157	Chemical Conversion Coat per QSI005 4.1	0.00							
157									
HandFinish	Memo	0.00							
Hand Finishing	1- realodine corners ***do not acid etch***								

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 Required Date: 6/12/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160									
Powdercoat	Memo <i>12/13/15</i>	0.00							
Powder Coating	1- touch up corner with alodine only 2- Plug holes prior to 1ST COAT: START TIME: <i>2:10</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>2:40</i> ***** 2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								<i>1</i> <i>15.7.8</i> <i>DAS 34 38</i>
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									<i>1</i> <i>15/07/14</i> <i>DAS 15 0-89</i>

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Cust Item ID:

Required Date: 6/12/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Assemble as per dwg	0.00							
180									
HandFinish	Memo	0.00							
Hand Finishing	1- Install webbing as per dwg								
	2- Install placard and label as per dwg								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>W/O</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									

04030-041/B133838

1x d' 15/07/14

① 15-07-14 DAS
9
9-89

1x d' 15/07/14

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Start Date: 6/08/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/12/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MCS

JUL 16 2015

MCS

JUL 15 2015

Picklist Print

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Work Order ID: 133338

133338

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 6/08/15

Required Date: 6/12/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2957		Manufactured	No			100	Each	19.0000	4	(4)			
D2957									**			DL 15/6/4	
Mounting Plate													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA004			19						
				113165			15						
				121584			(4)						
D3915-1		Manufactured	No			100	Each	4.0000	2	(2)			
D3915-1									**			DL 15/6/4	
Rib													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA004			4						
				116717			4						
D4016-5		Manufactured	No			100	Each	19.0000	3	(3)			
D4016-5									**			DL 15/6/4	
Hinge Half, Light Lid													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA004			19						
				114302			14						
				119528			5						

Picklist Print

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Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 6/08/15

Required Date: 6/12/15

Start Qty: 1.00

Required Qty: 1.00

D4019-3 Manufactured No

100 Each 6.0000 3

**

3

DL 15/6/4

D4019-3

Rib

Location

Loc Qty

Loc Code

WA004

6

116937

6

D4035-047

Manufactured No

100 Each 8.0000 2

**

3

DL 15/6/4

D4035-047

Lid Rib Assembly, Aft (Light)

Location

Loc Qty

Loc Code

WA004

8

116978

2

119496

6

D4056-1

Manufactured No

100 Each 22.0000 1

**

2

DL 15/6/4

D4056-1

Label Plate

Location

Loc Qty

Loc Code

WA004

22

120216

22

D2728-1

Manufactured Yes

180 Each 0.0000 0

**

1

DL 15/6/4

D2728-1

Dart Logo Label Small

D4029-041

Manufactured No

180 Each 7.0000 1

**

1

DL 15/6/4

D4029-041

Webbing (Long Basket)

Location

Loc Qty

Loc Code

ST498A

7

112334

2

114222

1

116892

4

XL

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Shop Packet Print

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Picklist Print

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Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 6/08/15

Required Date: 6/12/15

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W4

Purchased

No

180

Each

1,050.000

34

34

MS20600-AD4W4******

Rivets

LocationLoc QtyLoc Code

ST308

996

M132256

996

11132640

X34

WA003

54

M131624

54

NAS1149DN949J

Purchased

No

180

Each

328.0000

34

34

NAS1149DN949J******

Washer

LocationLoc QtyLoc Code

ST270

328

m128429

4

m128948

100

m128995

100

~~m129384~~

124

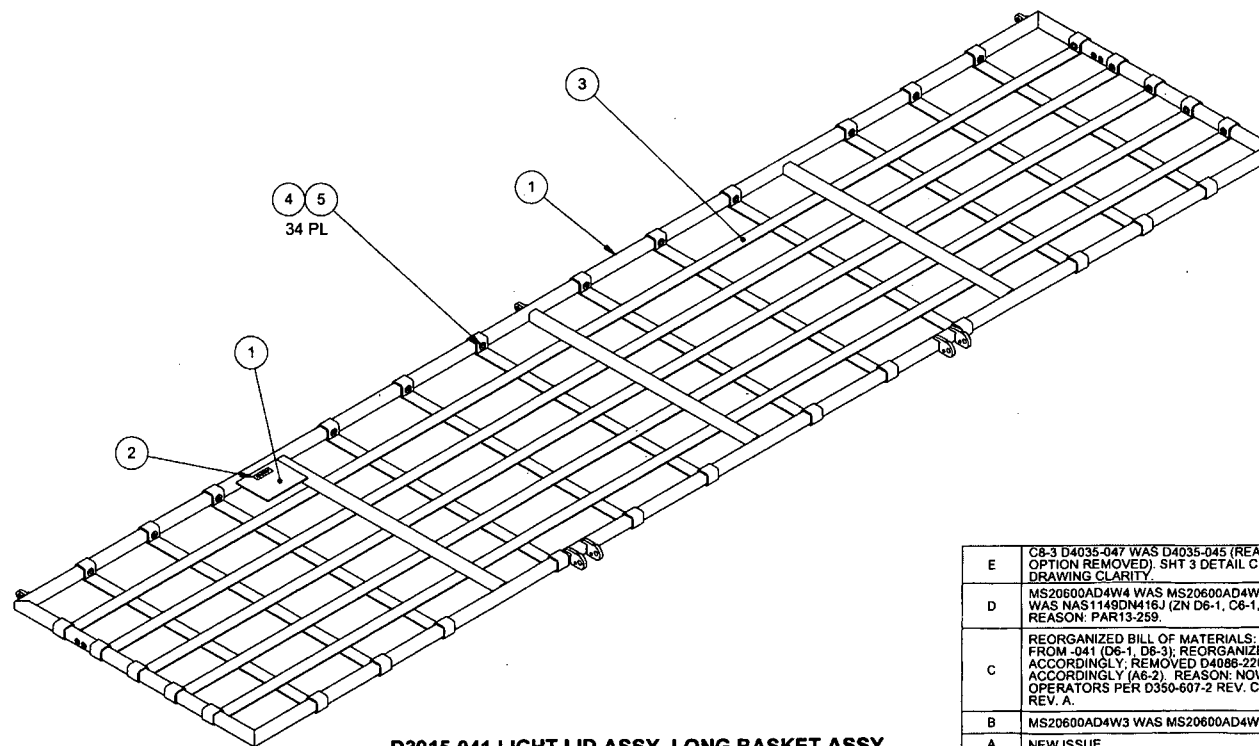
X34

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Shop Packet Print

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	NAS1149DN949J	WASHER
5	34	MS20600AD4W4	RIVET, BLIND, PAN-HEAD



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

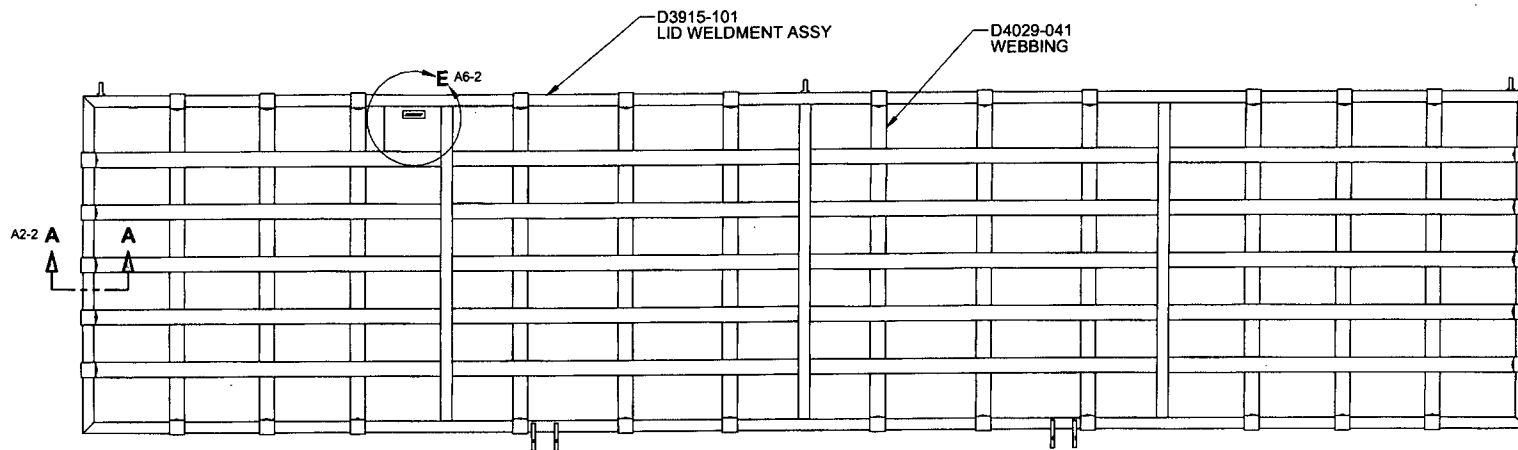
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.98 lbs

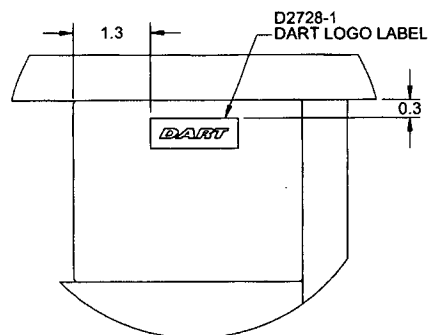
RELEASED
2013-08-16

E	CB-3 D4035-047 WAS D4035-045 (REASON PROFORM OPTION REMOVED). SHT 3 DETAIL C DELETED FOR DRAWING CLARITY.	AJS	13.07.18
D	MS20600AD4W4 WAS MS20600AD4W3; NAS1149DN949J WAS NAS1149DN416J (ZN D6-1, C6-1, B1-2). REASON: PAR13-259.	MB	13.06.19
C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3915	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LIGHT LID ASSY-LONG BASKET NTS	
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

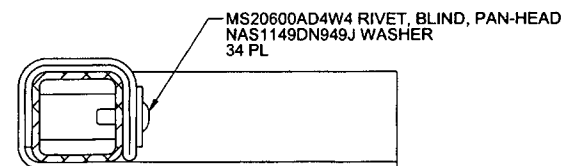
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6-4
133328



D3915-041 LIGHT LID ASSY, LONG BASKET



DETAIL E D6-2

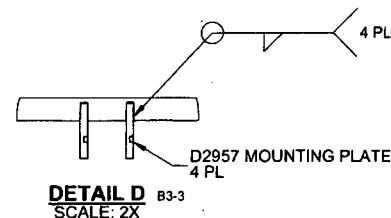
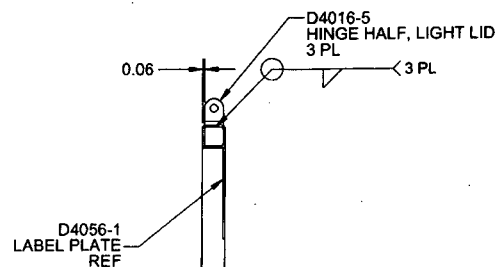


SECTION A-A C8-2
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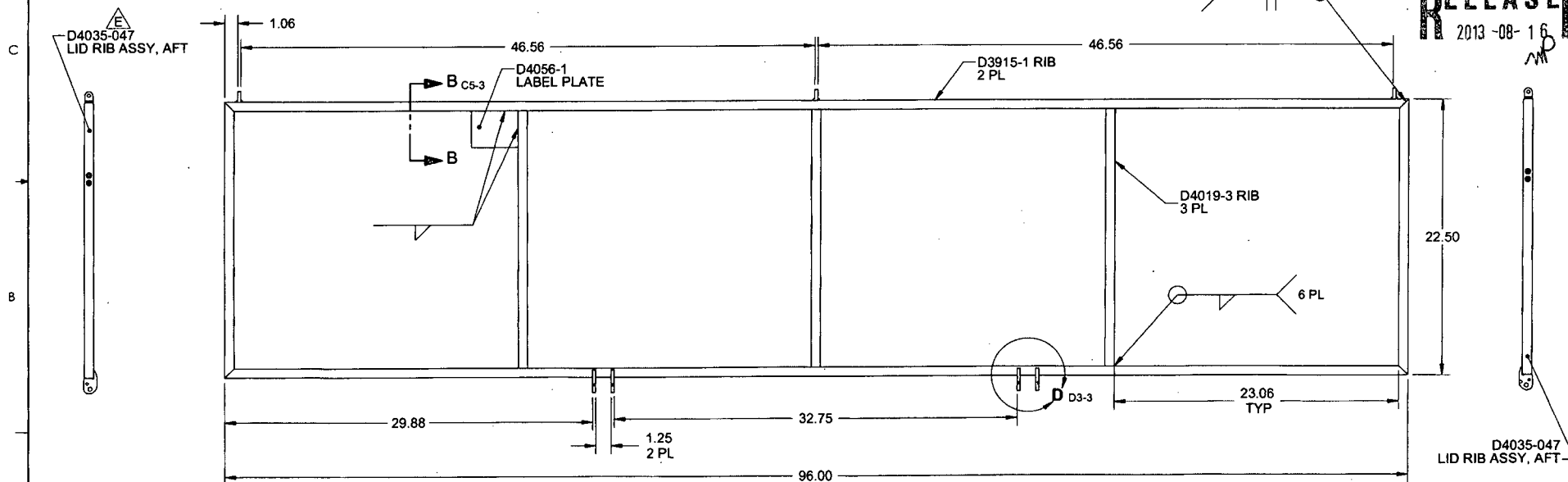
RELEASED
2013-08-16

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3915	REV. E
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	SCALE	
DE APPR.	<i>[Signature]</i>	TITLE LIGHT LID ASSY-LONG BASKET	
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	2	D3915-1	RIB
2	4	D2957	MOUNTING PLATE
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	2	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
6	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



SECTION B-B C6-3
SCALE: 2X



D3915-101 BASKET LID WELDMENT ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.82 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3915	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	
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2013-08-16

